

Work Order ID 82741

Thursday, April 05, 2012 1:01:37 PM

82741

Page 1

Item ID: D3697-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support Plate, LH
Start Date: 4/5/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/13/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: ✓ Date: 12-04-13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3697	Rev B

100 0.00
100 FLOW WATER JET
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3697Dwg Rev: B Prog Rev: B
60061 0.050 ***grain direction along 3.44" *** 2- Debur if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control

120 0.00
120 QC8- Inspect parts - second check
QC Memo 0.00
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3697	0.00 0.00		SB 1260413		(6)	8		
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		51760413		(86)	8		
150 *150* Small Fab Small Fab	Small Fab Memo I-counter sink hole as per dwg D3697	0.00 0.00				6x	8		PS 12/04/18

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Page 3

Item ID: D3697-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Plate, LH

Start Date: 4/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

(X)

/

(X)

SP

12-04-18.

12/4/19

mf
12-04-18

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Picklist Print

Thursday, April 05, 2012 1:02:02 PM

Page 1

Work Order ID: 82741

82741

Parent Item: D3697-3

D3697-3

Parent Item Name: Support Plate, LH

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No		100	sf	261.7940	0.4569	2.885684			

M6061T6S 050

**

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

021	160	
1211920	160	
MAT021	101.794	
113216	10	
114799	76.794	
114993	15	

121192

5m. M
12-4-11

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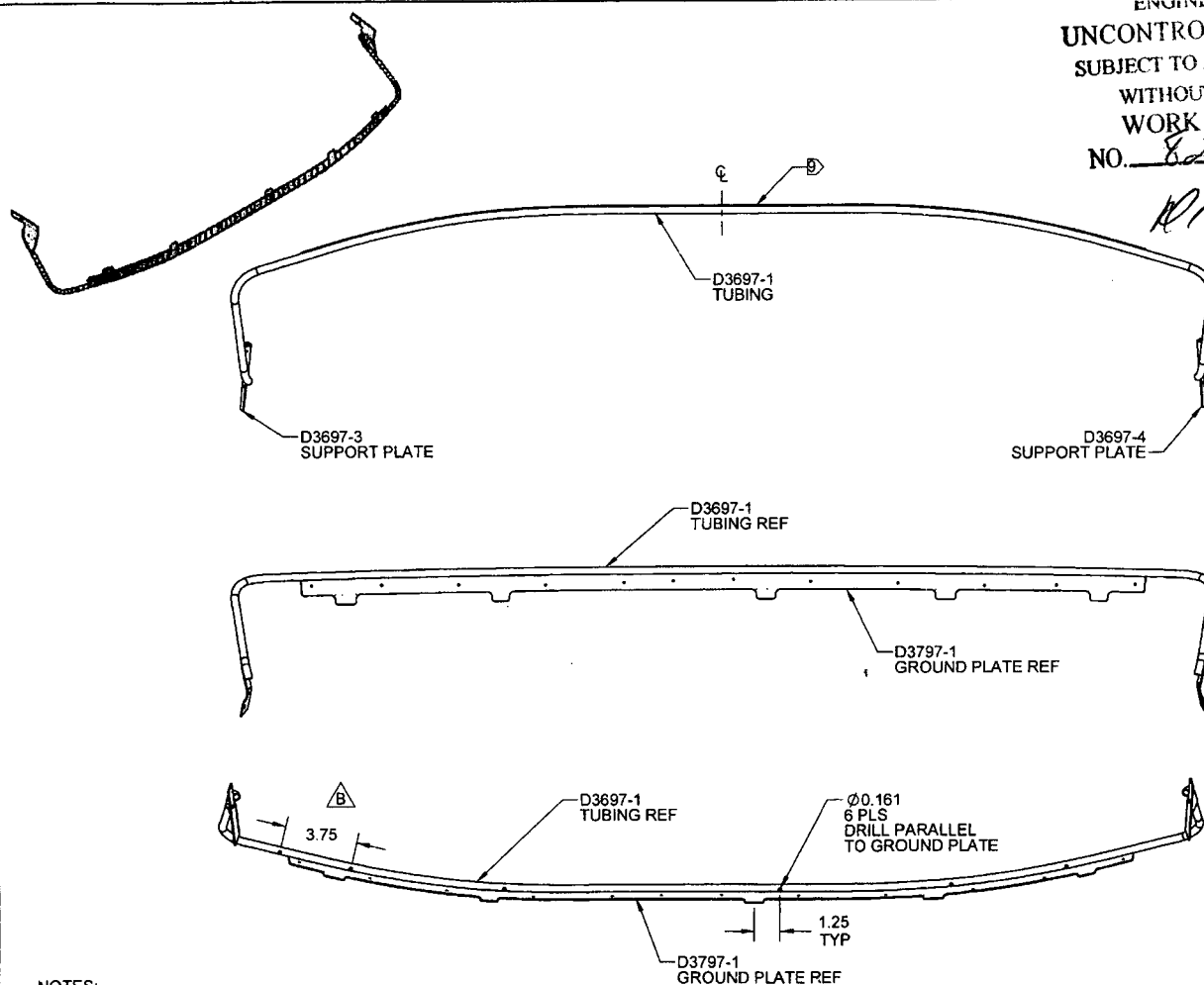
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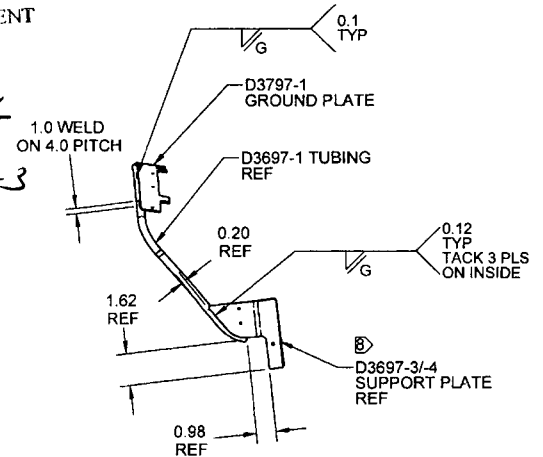
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82741
112-04-3



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A, B; ADD Ø0.161 HOLE. SHEET 1 ZONE B, 7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3697	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLY	NTS
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

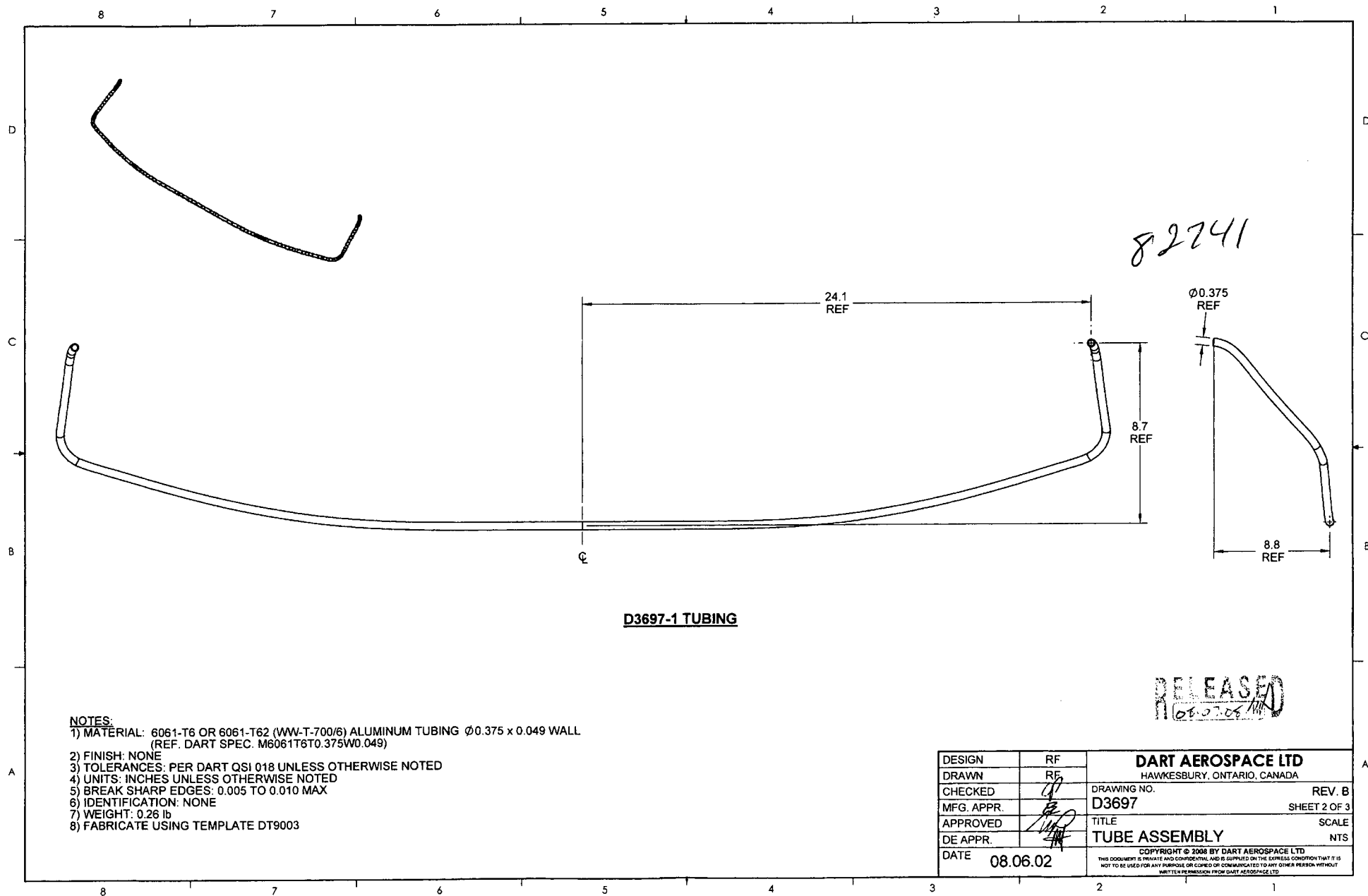
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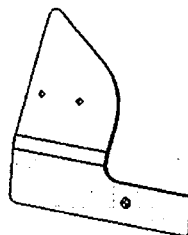
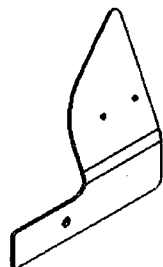
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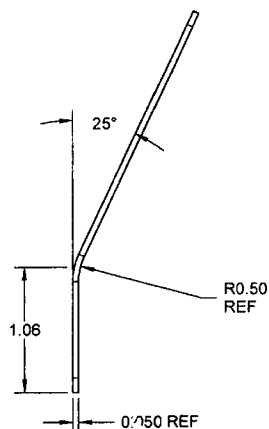
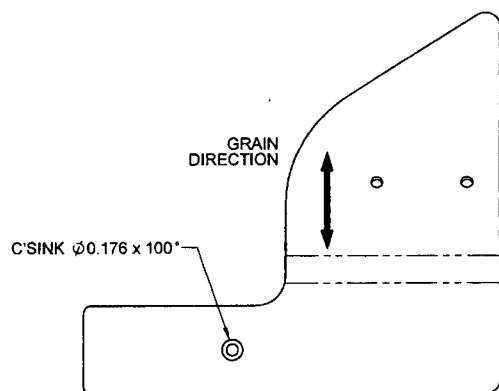
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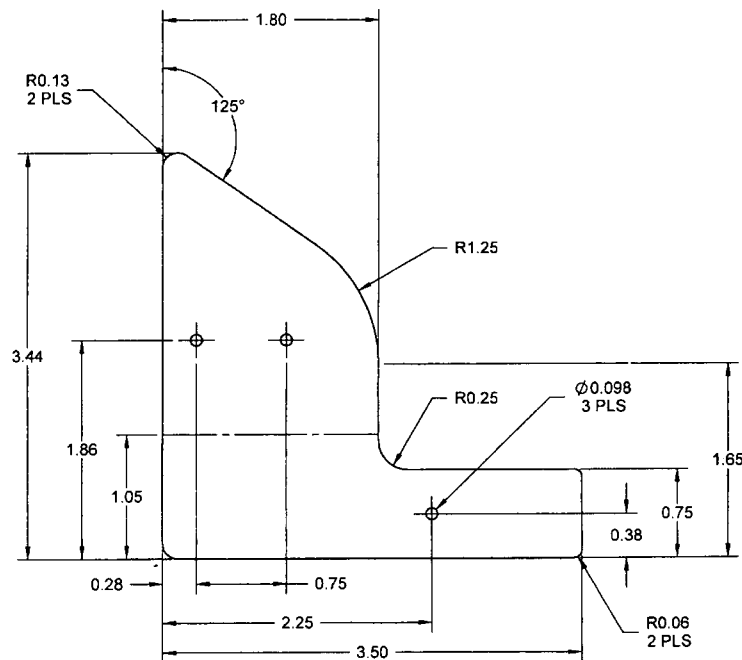


D3697-3 SUPPORT PLATE (LH SHOWN)

D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
 (MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

82741

RELEASED
 08-07-02

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3697	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLY	NTS
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